

Work Order ID 109313

November-19-13 7:57:28 AM

109313

Page 1

Item ID: D2596

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web, 205 Skidtube

Start Date: 11/19/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/03/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 13-11-19 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours-	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00

1000

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

13-11-20

DGL/B

110

Chemical Conversion Coat per QSI005 4.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

8 13-11-20 DGL

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control



DP 13-11-21

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Item ID: D2596 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205 Skidtube
 Start Date: 11/19/13 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/03/13 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>4/6</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DP 13-11-21
(8)

A/Bm 13/11/21

A/B-11-21

Picklist Print

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Work Order ID: 109313

109313

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 11/19/13

Required Date: 12/03/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

62.0000

1

D2500-3-100

**

8
8 B. 12/11/13

Ext'n - I' Beam Web 4"

Location

Loc Qty

Loc Code

LG

62

84873

4

89110

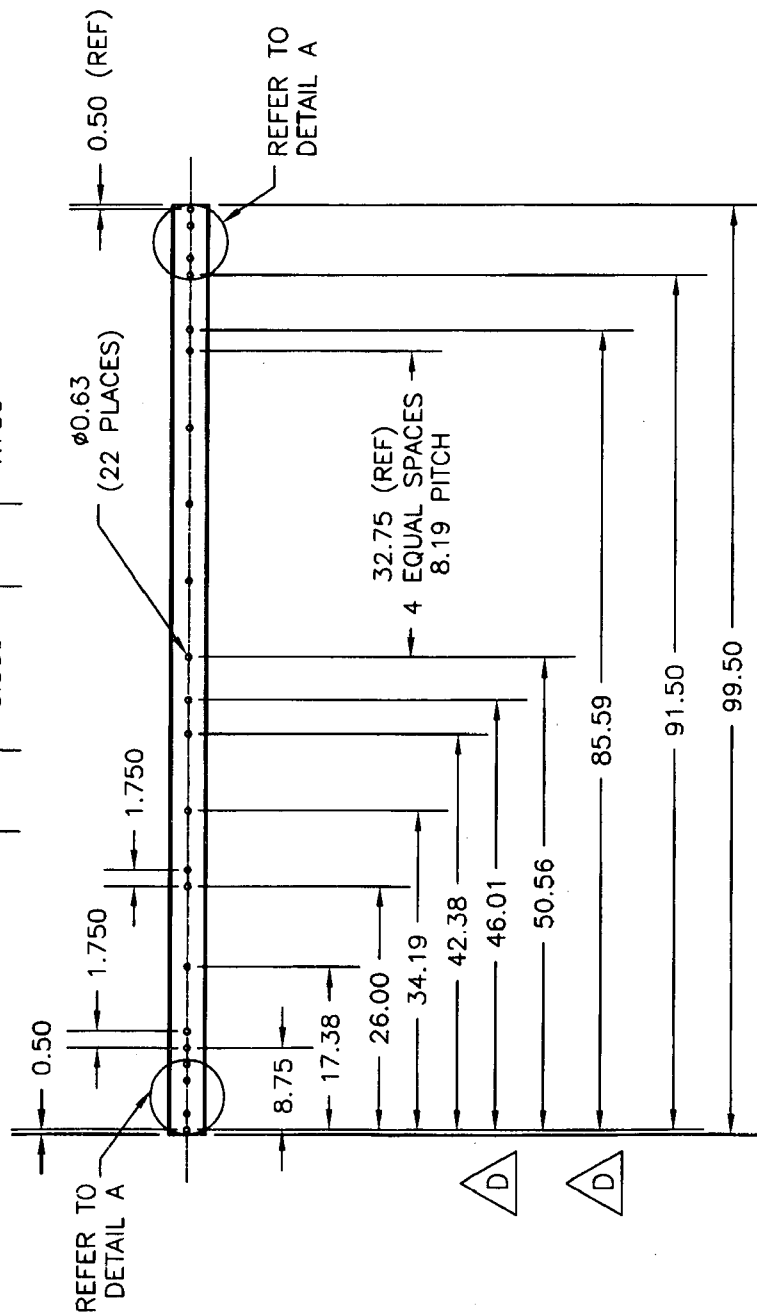
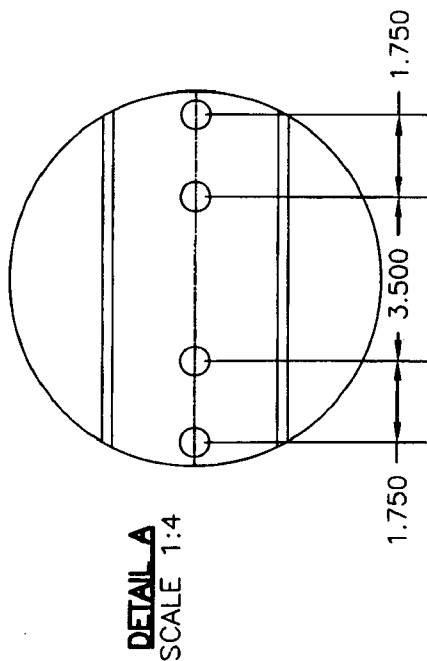
58



DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB	SCALE 1:20
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

RELEASED
07.06.18

109313 MUD
13-11-19



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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